

Date: Tuesday, 06/01/2009 10:04:25 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: CONSOLE SIDE FH (206 HI-SLOPE)		
Job Number	: 44392		Part Number	: D26022 D2601-2		
Estimate Number	: 11001		Drawing Number	: D2602 REV B		
P.O. Number	:		Project Number	: N/A		
This Issue	: 06/01/2009	S.O. No. :	Drawing Revision	: B		
Prsht Rev.	: NC		Material	:		
First Issue	: / /	Type	: SMALL /MED FAB			
Previous Run	: 43753		Due Date	: 31/01/2009	Qty:	4
Written By	:		Um:	Each		
Checked & Approved By	: JUN 09. 01.06					
Comment	: Est. E 04.02.25 Reformat KJ/RF Note: Issue with part number D2602-1 Est Rev:E Now On Waterjet 07-03-22 JLM Est Rev:F RevB as per dwg ECN1059 DD vereified by:EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S040	2024-T3 .040 sheet Comment: Qty.: 1.4146 sf(s)/Unit Total : 5.6582 sf(s) 2024-T3 .040 sheet Material: 2024-T3 (QQ-A-250/4) 0.040" thick (M2024T3S.040) Batch <u>110337</u> <u>FB 9-2-12</u>
2.0	WATER JET	FLOW WATER JET Comment: FLOW WATER JET 1-Cut as per Dwg D2602 *****Same Cutting File for -1 & -2 ***** Dwg Rev: <u>B</u> Prog Rev: <u>B</u> <u>FB 9-2-12</u> 2-Deburr if necessary <u>FB 9-2-12</u>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>FB 9-2-12</u>
4.0	QC8	SECOND CHECK Comment: SECOND CHECK <u>8 07/03/04</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

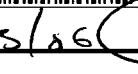
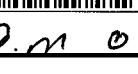
Part No: D2601-2 PAR #: N/A Fault Category: Prod / Eng. (Coordinator) NCR: Yes No DQA: D Date: 09/03/12
 Resolution: Process Rev.302 Disposition: Re-work QA: N/C Closed: D Date: 09/03/12

NCR: 44392		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/03/02	2.0	Incorrect parts made. D2602 as D2601. Employee worked off of the drawing & the incorrect drawing was attached. Affected WO's: 45390, 44391 45391: 44392	1/3/04 L	- See NCR 09-027 - Update this WO to a D2601	1 09/03/02	1/3/04 L	1/3/04 L	1/3/04 L

NOTE: Date & initial all entries

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Job Number: 44392		Part Number: D26022 D2601.2
Job Number:		
Seq. #:	Machine Or Operation:	Description :
5.0	BRAKE NC 	NC BRAKE 
Comment: NC BRAKE 1-Deburr if necessary 2-Form as per Dwg D2602		
6.0	QC5 	INSPECT WORK TO CURRENT STEP 
Comment: INSPECT WORK TO CURRENT STEP 		
7.0	HAND FINISHING1 	HAND FINISHING RESOURCE #1 
Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 		
8.0	QC3 	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION 		
9.0	PACKAGING 1 	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 		
10.0	QC21 	FINAL INSPECTION/W/O RELEASE 
Comment: FINAL INSPECTION/W/O RELEASE 		
Job Completion		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	44392
Description: CONSOLE SIDE	Part Number:	D2601-2
Inspection Dwg: D2601-2 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Φ .098	+ .004 - .001	.101	X			
13.00	+ .30	12.981	X			
1.35	+ .030	1.352	X			
1.375	+ .010	1.372	X			
.300	+ .010	.301	X			
6.000	+ .000	5.994	X			
9.45	+ .030	9.45	X			
10.96	+ .030	10.96	X			
8.875	+ .010	8.878	X			
.340	+ .010	.338	X			
.500	+ .000	.500	X			
.878	+ .010	.880	X			
1.254	+ .010	1.247	X			
2.47	+ .030	2.483	X			
.92	+ .030	.911	X			
11.239	+ .010	11.221	X			
10.76	+ .030	10.694	X			
13.75	+ .030	13.75	X			
14.18	+ .030	14.18	X			
.838	+ .000	.838	X			
2.640	+ .010	2.650	X			
.640	+ .010	.640	X			
			Σ			

Measured by:	B	Audited by:	S	Prototype Approval:	N
Date:	9-3-3	Date:	09/03/04	Date:	A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

